

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022084**Date Inspected:** 09-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 14, OBG 13CW (NWIT # 08104)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

FB3230-001-057, 058, 023~028

SEG3015G-004, 059, 060, 157, 158, 160, 161

SEG3015M-081~088

LD3033-001-073~076, 106~109

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W

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The Flux Cored Arc Welding (FCAW) process on weld joint nos: SEG3020BB-001, 028, 064 and 046 [Bottom Panel (BP) to Sub-Assembly (SA) Plate, complete joint penetration (CJP) weld]. The welders are identified as 067949, 045276, 066236 and 066695 for the respective welds and were observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020AG-008 (BP to SA Plate, CJP weld). The welders are identified as 201215 and 066734 and were observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020AG-003 [Edge Plate (EP) 3030C to Floor Beam (FB) 3329A, CJP weld, at panel point (PP) 127]. The welder is identified as 045175 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020G-026 (FB3334B to FB3339A, CJP weld, at PP128). The welder is identified as 047864 and was observed welding in the 1G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-B-U2-FCM.

The FCAW process on weld joint no: DP3172-001-133 [U-rib to Deck Panel (DP) diaphragm, fillet weld]. The welder is identified as 045143 and was observed welding in the 3F position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020BB-001 [Sub Assembly (SA) plate SA3443A to Bottom Plate (BP) 3087A, CJP weld in between panel points (PP) 125~126]. The welder is identified as 068445 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

During random in process inspection this QA inspector observed there was no cope holes made at two locations on the web plate of Floor Beam (FB) 3323B at Panel Point (PP) 126.5. As per shop drawing it shows cope holes supposed to be there. This issue has been discussed with ZPMC CWI Mr. An Qing Xiang and CT Lead QA. Mr. An Qing Xiang informed this QA that this issue would be corrected in manner compliant with contract documents. Attached photograph provide additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
